

Work Order ID 60253

June 30, 2010 7:57:40 AM



Page 1

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 30/06/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 05/07/2010 Req'd Qty: 6.00

Customer:

Reference: *Ind 10-12-20*

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2932

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

B.A 10/06/30

6

Ø

B.A 10/06/30

6

Ø

B.A 10/06/30

6

Ø

Work Order ID 60253

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Item ID:	D2932-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle RH Out, 206				Stop	
Start Date:	30/06/2010	Start Qty:	6.00			
Required Date:	05/07/2010	Req'd Qty:	6.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	φ		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				6	BR	10-7-6	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M114841 Memo START TIME: 11:00 300 ° FINISH TIME: 11:36	0.00 0.00				6	BR	10-7-6	

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Item ID: D2932-2	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle RH Out, 206					
Start Date: 30/06/2010	Start Qty: 6.00		Cust Item ID:		
Required Date: 05/07/2010	Req'd Qty: 6.00		Customer:		
Reference:					
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Start
					Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		10107106		X6	Ø		
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>428</u> Memo	0.00 0.00							10-7-7 sl (64)
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							ME 10-7-7

Picklist Print

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Page 1

Work Order ID: 60253

Parent Item: D2932-2

Parent Item Name: Saddle RH Out, 206


Start Date: 30/06/2010

Required Date: 05/07/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	40.0000	1	6			

Saddle Billet, 7075

Location

Loc Qty

Loc Code

MAT042

40

59196

40

6.000 b.A 10/06/30

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Production Engineering Coordinator

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60253

DART AEROSPACE LTD		Work Order:	<i>58262</i>
Description: 206 Saddle, Outboard, Right side		Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.132	0.130	0.128	0.130		
B	0.100	0.140		0.133	0.129	0.128	0.130		
C	0.100	0.140		0.129	0.125	0.125	0.123		
D	0.210	0.230		0.226	0.227	0.227	0.227		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.51	0.51	0.51	0.51		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.260	0.260	0.260	0.260		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.237	0.237		
N	0.100	0.140		0.110	0.110	0.110	0.110		
O	0.540	0.560		0.551	0.551	0.551	0.551		
P	0.490	0.510		0.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		0.258	0.256	0.256	0.257		
T	0.100	0.180		0.130	0.130	0.130	0.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.125	1.145		1.134	1.137	1.136	1.137		
Y	1.565	1.585		1.568	1.573	1.573	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>M. A</i>
Date:	<i>10/06/30</i>

Audited by:	<i>[Signature]</i>
Date:	<i>10/07/05</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 58266
Description: 206 Saddle, Outboard, Right side		Part Number: D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	3	4		
A	0.100	0.140		0.128	0.129				
B	0.100	0.140		0.128	0.130				
C	0.100	0.140		0.117	0.118				
D	0.210	0.230		0.228	0.228				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.260	0.260				
L	0.312	0.317		0.314	0.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		0.110	0.110				
O	0.540	0.560		0.551	0.551				
P	0.490	0.510		0.501	0.500				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		0.258	0.256				
T	0.100	0.180		0.130	0.130				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.317	0.317				
X	1.125	1.145		1.137	1.137				
Y	1.565	1.585		1.574	1.574				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: H.A
Date: 10/06/30

Audited by: SA
Date: 10/07/05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

